

# Work Order ID 57363

April 6, 2010 8:34:21 AM



Page 1

Item ID: D3571-3

Accept



Setup Start



Revision ID:

Item Name: Guide

Stop



Start Date: 06/04/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 16/04/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

*BT*

Date: *10-4-06*

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3571

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 2.90 " long

*10-4-14*

*(10)*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA681 Rev. *AT* & Dwg D3571 Rev: *1* ☐ 2-Debur  
per dwg D3571

*10-4-14*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*10-4-14*

*(10)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 57363

April 6, 2010 8:34:21 AM



Page 2

Item ID: D3571-3

Accept



Setup Start



Revision ID:

Item Name: Guide

Stop



Start Date: 06/04/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 16/04/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00	LB 10/04/14			10			
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				10			BL 10-4-14.
150  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 1112588 Memo	0.00  0.00							
	START TIME: 9:00am FINISH TIME: 9:30am OVEN TEMPERATURE: 320°F								

→ JV 10/04/16 10 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

[illegible]

Page 3

**Accept**

**Setup Start**

**Stop**

**Cust Item ID:**

(b) (7)(C), (b) (7)(D)

(b) (7)(C), (b) (7)(D)

**Customer:**

**Reference:**

Run Start

**Stop**

**Insp.  
Stamp**

0.00

**00000000000000000000**

0.00

## Quality Control

0.00



0.00

## Packaging

0.00

**Abstract**

0.00

## Quality Control

10 BL 10-4-16

10-416 (100) 50

10/04/19 *AF*

MF

10-4-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

April 6, 2010 8:34:29 AM

Page 1

Work Order ID: 57363



Parent Item: D3571-3



Parent Item Name: Guide

Start Date: 06/04/2010

Required Date: 16/04/2010

Comments: IPP Rev:A New Issue 07-02-01 JLM

Start Qty: 10.00

Required Qty: 10.00

IPP Rev:B Remove manual Machinig 08-05-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0		Purchased	No			110	f	0.0000	2.5368			



6061-T6 Bar .750 X 1.50



.75 x 2.0  
this batch  
only

1111448

10-4-13

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order:	57363
Description: Guide		Part Number:	D3571-3
Inspection Dwg: D3571	Rev: A	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	.700	/	/		
2.75	+/-0.030	2.750	/	/		
1.38	+/-0.030	1.375	/	/		
1.25	+/-0.030	1.247	/	/		
0.63	+/-0.010	.625	/	/		
0.031 chamfer	+/-0.010	.031	/	/		
Ø0.500	+0.006/-0.001	.501	/	/		
Ø0.201	+0.005/-0.001	.201	/	/		
R0.25	+/-0.030	0.25	/	/		
0.260	+0.000/-0.010	.254	/	/		
Ø0.385 x 100°	+0.006/-0.001 x 0.5°	.385	/	/		
0.125	+/-0.010	.125	/	/		
2.250	+/-0.010	2.241	/	/		
0.250	+/-0.010	.247	/	/		
0.188	+/-0.010	.190	/	/		
0.063 chamfer	+/-0.010	.063	/	/		

Measured by:	<i>[Signature]</i>
Date:	10.4.13

Audited by:	<i>[Signature]</i>
Date:	10/04/14

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

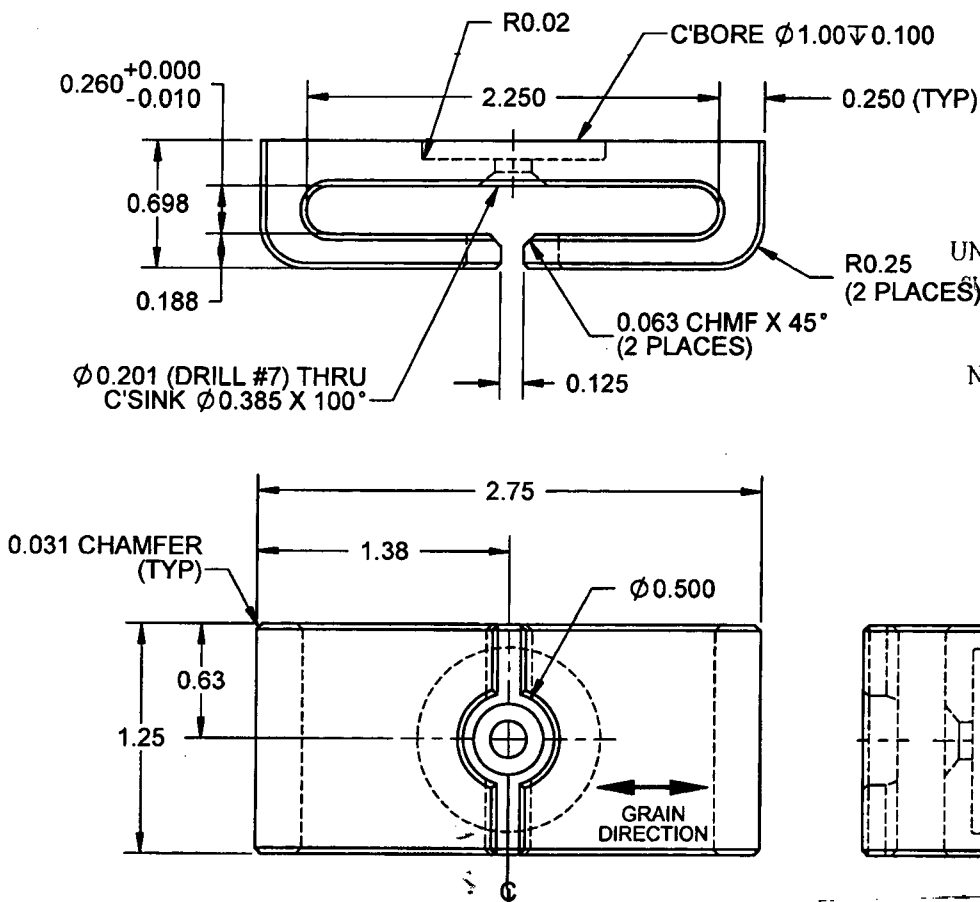
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3571	REV. A SHEET 1 OF 2
DATE 07.01.29		TITLE GUIDE	SCALE 1:1
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE	

RELEASED  
07.04.12 *[Signature]*



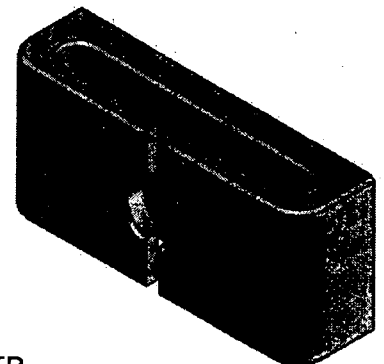
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WITHOUT NOTICE  
WORK ORDER  
NO. 57363

*07104-06*

### D3571-1 GUIDE

#### NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR  
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116  
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT  $\phi$



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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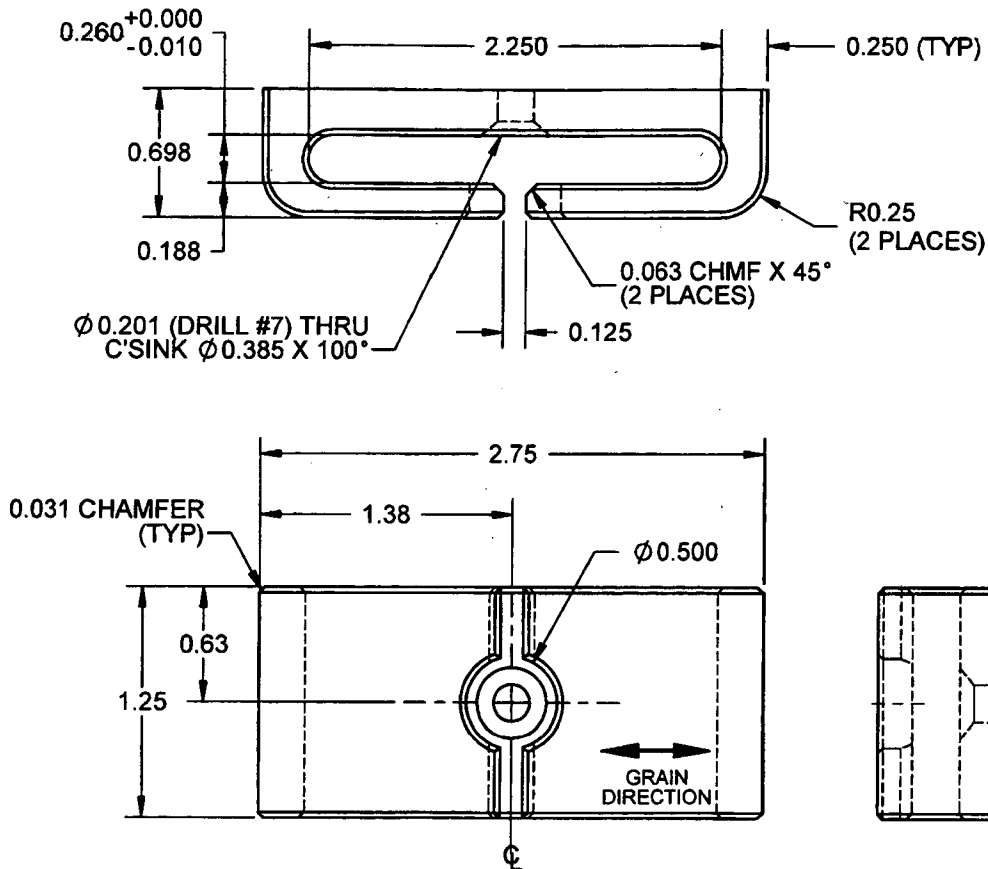
**NOTE:** Date & initial all entries

**DART**

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3571</b>	REV. A SHEET 2 OF 2
DATE <b>07.01.29</b>		TITLE <b>GUIDE</b>	SCALE 1:1

RELEASED  
07.04.12 *[Signature]*

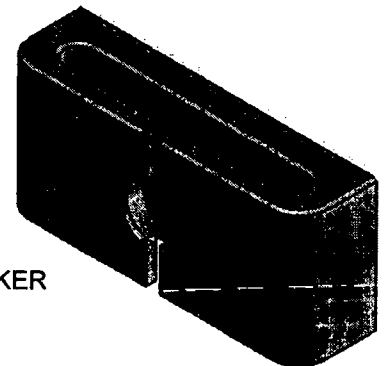
*w/057363*



**D3571-3 GUIDE**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR  
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116  
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- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
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